

Work Order ID 77423

77423

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Tuesday, December 06, 2011 2:17:20 PM

Item ID: D3685-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: BIPOD MOUNT ASSEMBLY
 Start Date: 12/6/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/9/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: WKF Date: 11-12-06 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3685	Rev D

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									

110	Small Fab	0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3685								
	2-Assemble D3684-047 & D3687-3 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3685								
	***Ensure holes for AN3C Bolts are free of sealant. Torque Fastners as per Dwg D3685								

EP 11/12/08 ①

EP 11/12/08 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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11-12-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 77423

Parent Item: D3685-041

Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 12/6/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
 03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD
 IPP REV:C AS PER REV D 10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A Bolts		Purchased	No			110	Each	90.0000	4	4		12/11/08	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST351		90							
				117514		4							
				118112		5							
				118422		17							
				118451		22							
				119510		42			4				
D3684-047 FWD LEG ASS'Y		Manufactured	No			110	Each	0.0000	1	1		12/11/08	
D3684-049 AFT LEG ASS'Y		Manufactured	No			110	Each	0.0000	1	1		12/11/08	
D3687-3 MOUNT		Manufactured	No			110	Each	0.0000	1	1		12/11/08	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		6							
				61890		2							
				61964		4							
D3692-1 SPACER		Manufactured	No			110	Each	141.0000	8	8		12/11/08	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST075		141							
				51467		41							
				73232		100							

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Parent Item: D3685-041

Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 12/6/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

110

Each

856.0000

4

4

Nut

Handwritten signature and date: 12/11/08

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

784

118077

1

118614

449

118686

104

119758

230

Handwritten number 4

W/O:		WORK ORDER CHANGES					
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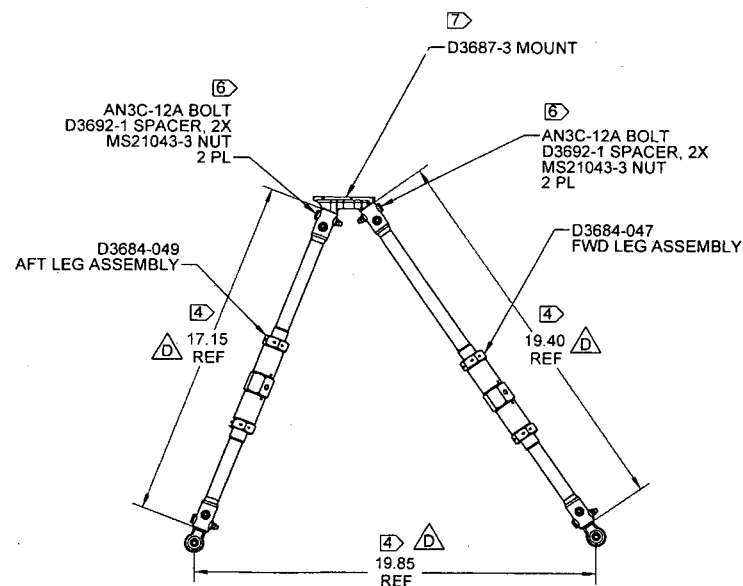
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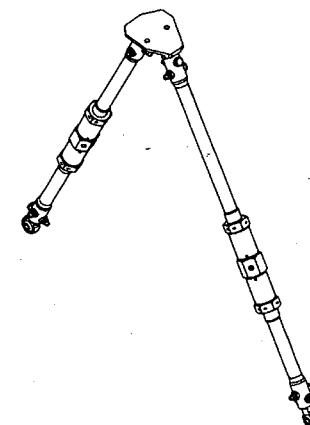
ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3685-041 BIPOD MOUNT ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT



RELEASED
2010-03-15
MP

D	17.15 WAS 17.27 (ZN B6-1); 19.40 WAS 19.52 (ZN B4-1); 19.85 WAS 20.24 (ZN B5-1)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3685	REV. D
TITLE BIPOD MOUNT ASSEMBLY	SHEET 1 OF 1
SCALE NTS	
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